



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2121
Job Sheet 169510



Part No: D2121

Job Qty: 6 ea

Part Name: Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV D IPP: D 04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/28/17	0.00	0.00	Start Up Large Fab-1		DYC 17/12/15
100	Large Fab	6 pcs		12/28/17	0.00	2.13	Large Fab 1		DYC 17/12/15
110	QC	6 pcs		12/28/17	0.00	0.00	QC9		EF
120	Small Fab	6 pcs		12/29/17	0.00	4.35	Small Fab-1		EF
130	QC	6 pcs		12/29/17	0.00	0.00	QC5		38
140	Packaging	6 pcs		12/29/17	0.00	0.00	Packaging3-1		JAN 17 2018
150	QC21-SA	6 Ea		12/29/17	0.00	0.00	QC21		JAN 17 2018

Part Op 100 - Weld washer & wing nut as per Dwg D2121 & QSI 004 Identify as Wing Nut assembly
Descriptions: 120 - Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121. Drill and deburr hole in coupling nut as per Dwg D2121. (Note: Install MS21042L4 Nut loosely) Cut D2771-BCFC-025-150 at 1.500"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	5/16-18 SS WING NUT	6	35	0	0
	5/16WC	6	1,117	0	0
120-Small Fab	5/16-18 SS JAM NUT	6	0	0	0
	5/16-18 SS THREADED	6	9	0	0
	5/16-18SS1COUPLING	6	9	0	0
	AN4-4A	6	61	0	0
	D2012-107-B1599/12 -	6	4	0	0
	D2529	30	1,704	0	0
	D2771-BCFC-025-150	6	667	0	0
	D2771-LCC-025	6	578	0	0
	MS21042L4	6	4,432	0	0
	NAS1149D0463J	6	4,919	0	0

Part Specifications

Specifications could not be found.

D 2529 5019348
~~501488~~
~~501488~~
~~501488~~

Plex 12/13/17 11:24 AM dart.poulin.mario

DQA:

QA Closed:

Work Order

Part No

NCR No

Date :

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

DART
AEROSPACE**S022760****Clamp Assembly****D2121****Start up Operation****Mfg Date: 12/15/17****Job No: 169510****PART NO:
Revision:
Operation:
Change No:****CONFORMANCE / UPDATE**Work Order update only ☐**DART**
AEROSPACE**AGAINST DEPARTMENT/PROCESS**

Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval**FAULT CATEGORY**

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Setup	☐	Folio/Program	☐	Outside Dimensions	☐
M/R/Route	☐	Grain	☐	Over/Under tolerance	☐
Weld	☐	Wrong Stock Pulled	☐	Part Incorrect	☐
Weld	☐	Out of Sequence	☐	Part Lost/Missing	☐
Weld	☐	Off-set	☐	Part Moved	☐
Weld	☐	Mislabeled	☐	Drawing	☐
Weld	☐	Fit/Function	☐	Finish	☐
Weld	☐	Misaligned/off center	☐	Misread	☐
Weld	☐			Turning Sequence	☐

Environment

Design

Doc/Data

Equip/Tooling

Handling/Pre

Material

Internal Transport

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

Use for Testing

Poor Information

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due

Clamp/Kink/Kipple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

OTHER :



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: AN4-4A Revision: Bolt														
100	Receive Ea	S032240	169510	1 Ea	0		ST346		Stock	1/15/2018	Issue Container			
		S032241	169510	5 Ea	0		ST346		Stock	1/15/2018	Issue Container			
Operation Totals:		2		6	0									
Part Totals:		2		6	0									
Part Number: D2121 Revision: Clamp Assembly														
150	QC21-SA	S022760	169510	6 Ea	0	S022760	ST002	Bin	Stock	12/15/2017	Issue Container			
Operation Totals:		1		6	0									
Part Totals:		1		6	0									
Totals:		3		12	0									

Plex 1/17/2018 1:09 PM Dart.Lajeunesse.Marie